

Split

Work Order ID 69322-1

Monday, May 09, 2011 8:51:05 AM



Page 1

Item ID: D3245-043

Revision ID:

Item Name: Door Assembly

Start Date: 5/9/2011 Start Qty: -6.00

Required Date: 5/12/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

QC:

Date: 5/05/11

Date:

Tooling:

SPC (Y/N):

Date:

Date:

- Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3245

Rev B

100

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

110

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Install Studs and Gromets as per Dwg D3245 3-Bond Gasket using 3M
ADHESIVE as per Dwg D3245 A/R 3M 1300/1300L ADHESIVE
Batch: M15230

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control



Setup Start

Stop

Cust Item ID:

Customer:



4511/05/18 (8)

4511/05/19 (8)

5116517

(8)

Work Order ID 69322

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Page 2

Item ID: D3245-043
Revision ID:
Item Name: Door Assembly

Start Date: 5/9/2011 Start Qty: 6.00
Required Date: 5/12/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

Identify as per dwg & Stock Location: 233B

0.00

Packaging

Memo

0.00

Packaging

140

QC21 - Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Accept



Setup Start

Stop



Cast Item ID:

Customer:

Run Start

Stop



11/5/1954 (12)

11/5/1954

11-05-19 (1)

Picklist Print

Monday, May 09, 2011 8:51:11 AM

Page 1

Work Order ID: 69322

Parent Item: D3245-043

Parent Item Name: Door Assembly



Start Date: 5/9/2011

Required Date: 5/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-11 JLM Verified By:EC
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

127H-35

Purchased

No

100

Each

20.0000

8

48



HALF GROMMET

Location

Loc Qty

Loc Code

ST198

20

117203

20

2351-20-009-C3Y

Purchased

No

110

Each

38.0000

8

48



STUD

Location

Loc Qty

Loc Code

ST400

38

111733

12

117358

20

15447

6

D3245-3

Manufactured

No

110

Each

0.0000

1

6



Door

D3245-7

Manufactured

No

110

Each

1.0000

1

6



Gasket

Location

Loc Qty

Loc Code

GA

1

69041

1

369553 (7x)

8/5/05/19

15

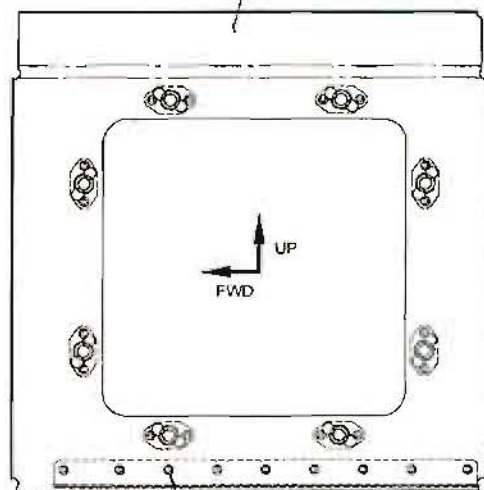
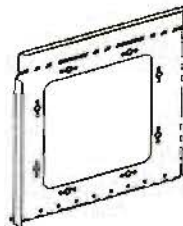
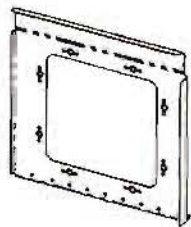
8/5/05/19

16

8/5/05/19

8/5/05/19

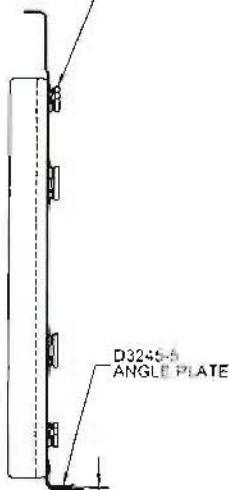
W1069322



MS20615M3-3 RIVET
(8 PLACES)

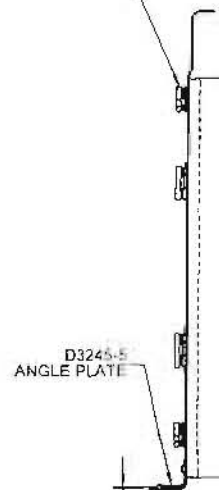
D3245-041 ACCESS PANEL ASSEMBLY

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

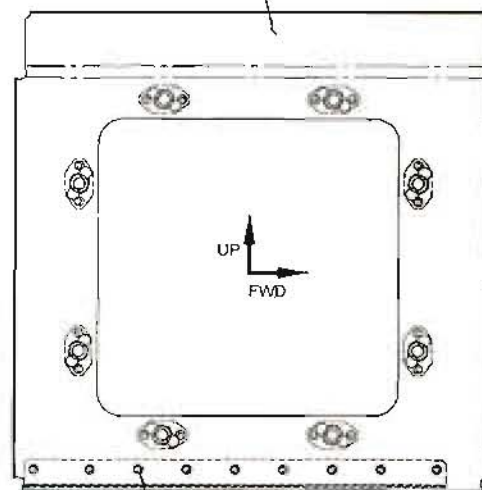


0.032
GAP

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



0.032
GAP



MS20615M3-3 RIVET
(8 PLACES)

D3245-042 ACCESS PANEL ASSEMBLY

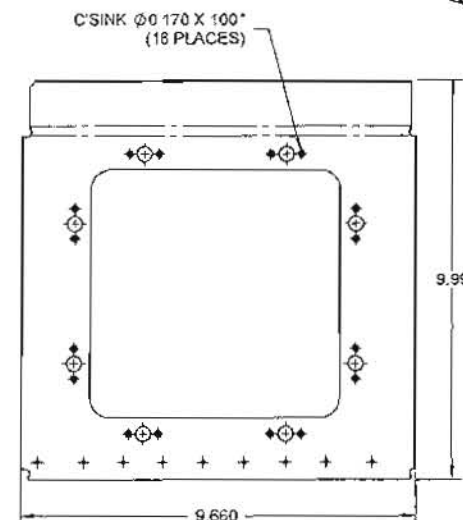
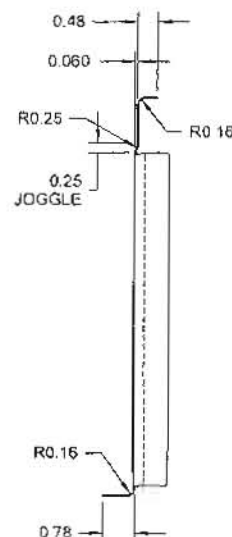
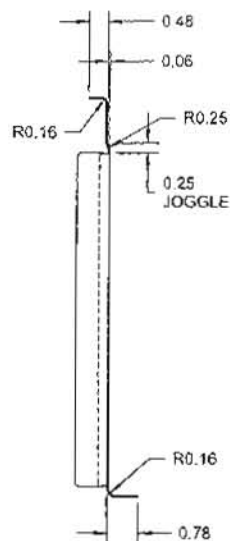
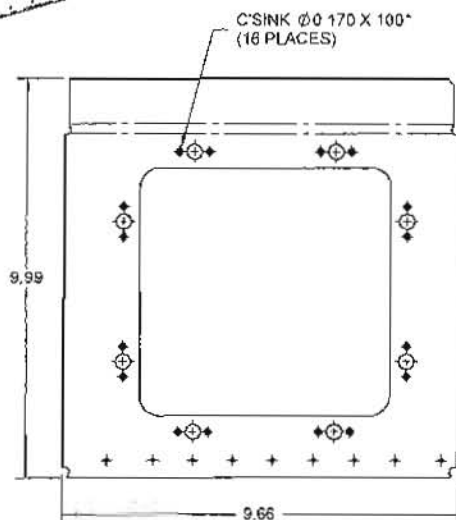
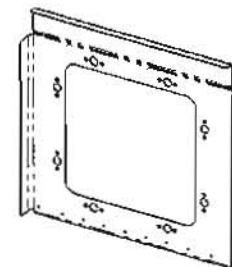
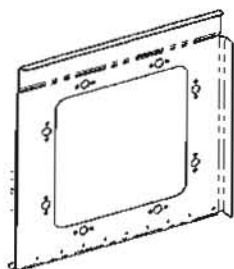
RELEASED
17/02/03

NOTES

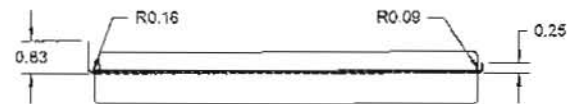
- 1) MATERIAL N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 010 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT 0.83 lbs

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
8	8	MS20615M3-3	RIVET

B	REMOVE 2350-18-C3Y DZUS RIGID RECEPTACLE FROM D3245-041-042. REMOVE MS20427M3-3 RIVETS & TURNER & BUCKLE CLASSETS FROM D3245-041-042. HOLES AND TURNS ARE NOW PART OF INSTALLATION. ASSIGN PINS TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	MB	04.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG APPR	<i>[Signature]</i>		
DE APPR	<i>[Signature]</i>		
DATE	07.10.02		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO D3245 TITLE ACCESS PANEL ASSEMBLY SCALE 1:2.5 <small>Copyright © 2004 by Dart Aerospace Ltd. All rights reserved. No part of this drawing may be reproduced without the written permission of Dart Aerospace Ltd.</small>			



D3245-1 PANEL BEND DETAIL, LH



D3245-2 PANEL BEND DETAIL, RH

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10-10-23

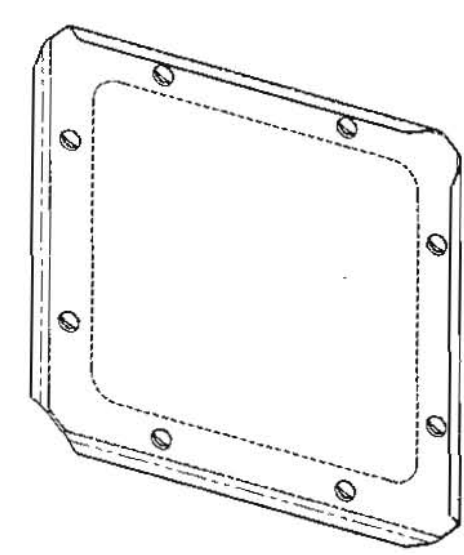
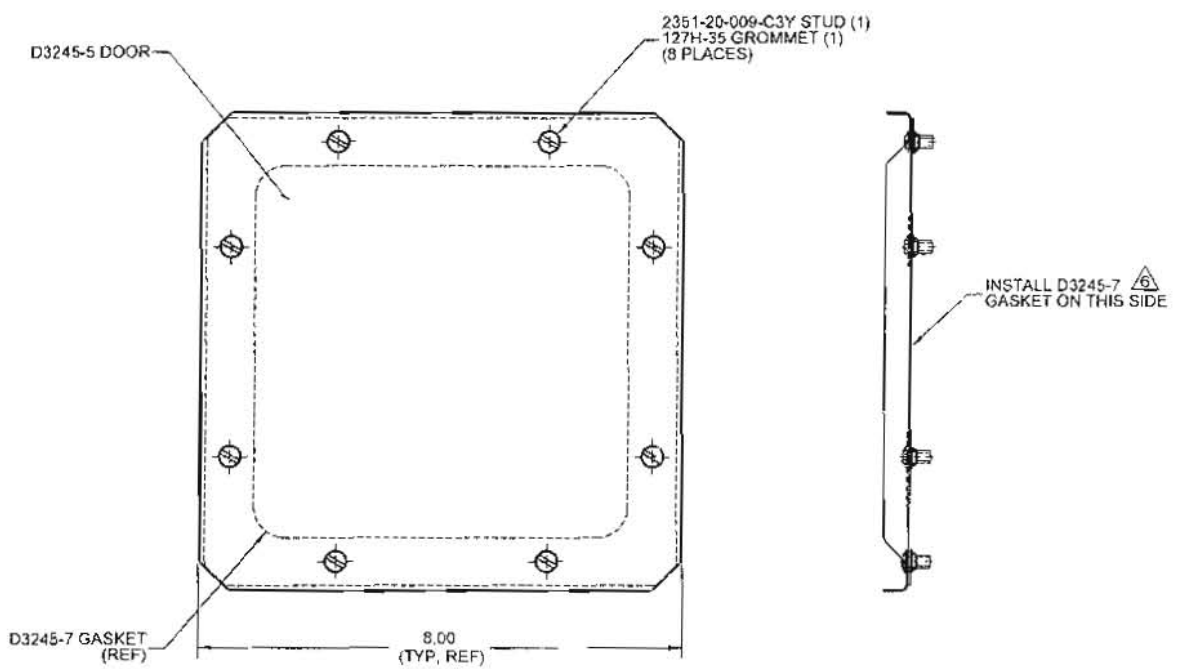
NOTES

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES N/A
- 6) IDENTIFICATION N/A
- 7) WEIGHT: 0.70 lbs

W1069322

DESIGN	TH	DART AEROSPACE LTD	
DRAWN	TH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	TH	DRAWING NO.	REV. B
WFG APPR	TH	D3245	SHEET 2
PROVED	TH	TITLE	1:1
DE APPR	TH	ACCESS PANEL ASSEMBLY	
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



D3245-043 DOOR ASSEMBLY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

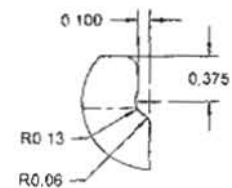
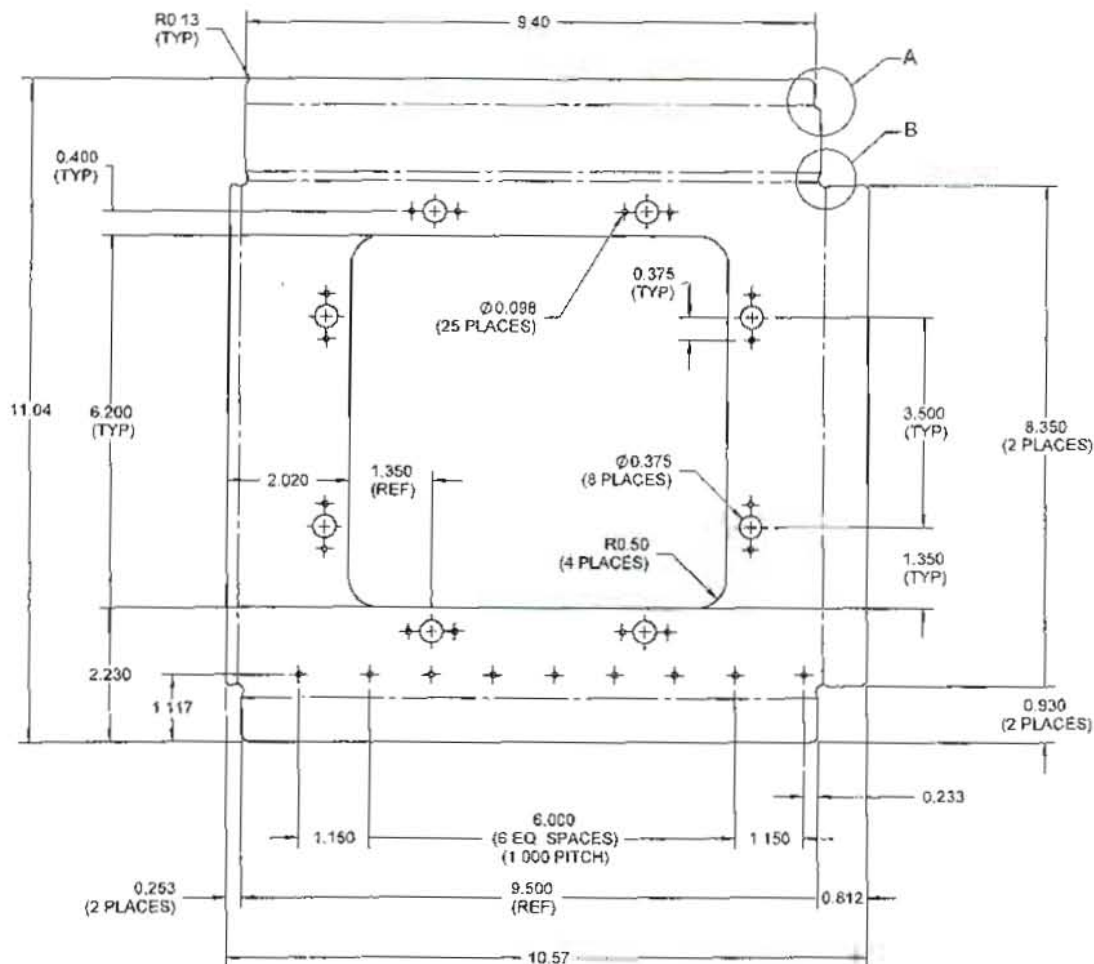
- NOTES**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
 - 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 - 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
 - 9) WEIGHT: 0.73 lbs

W6 69322

RELEASED
7/10/02

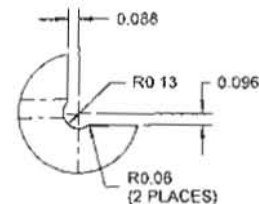
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DRAWN	PH	DRAWING NO.	REV. B
CHECKED	DS	D3245	SHEET 3 OF 7
MFG APPR.	DS	TITLE	SCALE
APPROVED	DS	ACCESS PANEL ASSEMBLY	
DE APPR	DS	1.2	
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8 7 6 5 4 3 2 1



DETAIL A: RELIEF
SCALE 1:1

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DETAIL B: RELIEF
(TYP. 4 PLACES)
SCALE 1:1

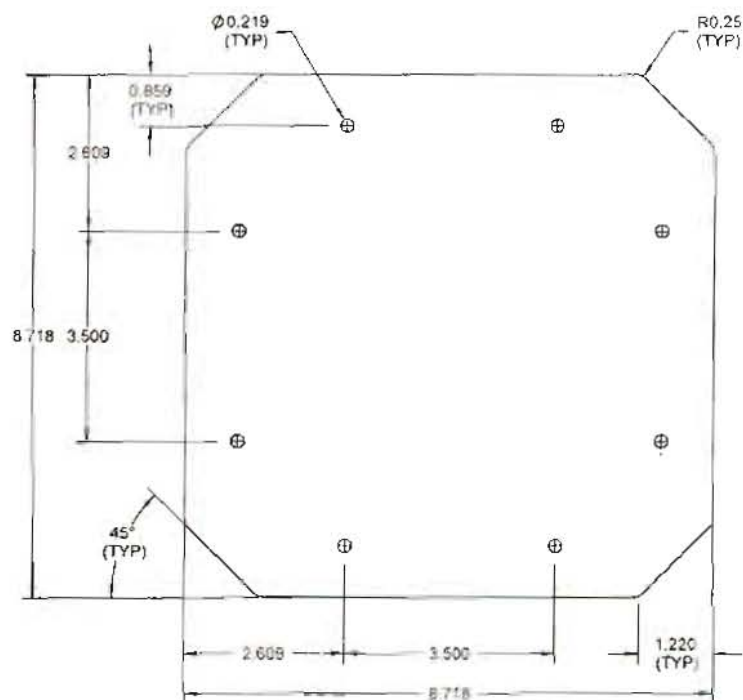
NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

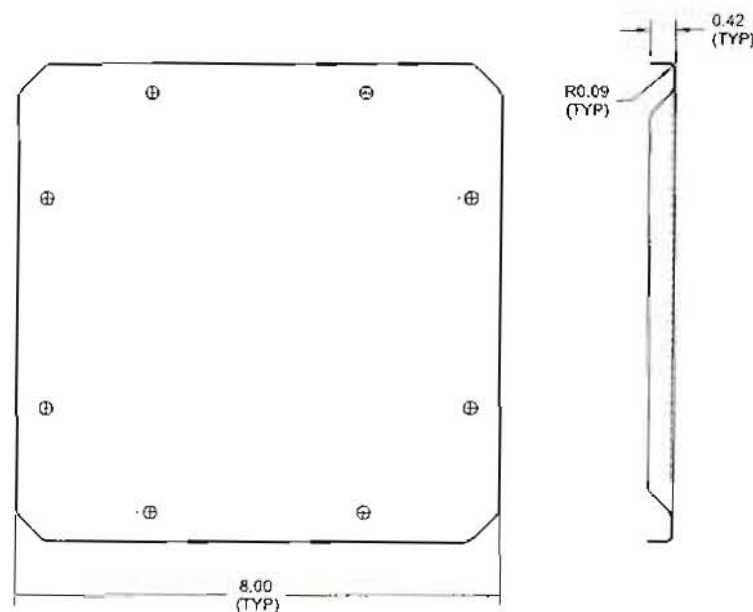
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DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO	REV. B
MFG APPR.	<i>PH</i>	D3245	SHEET 4 OF 7
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	ACCESS PANEL ASSEMBLY	1:2
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D3245-1F PANEL FLAT PATTERN

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07-10-23



D3245-3F DOOR FLAT PATTERN



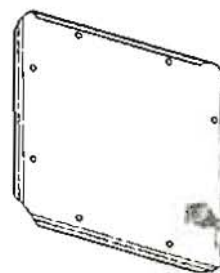
D3245-3 DOOR BENDING DETAIL

u/b 49328

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07-10-02

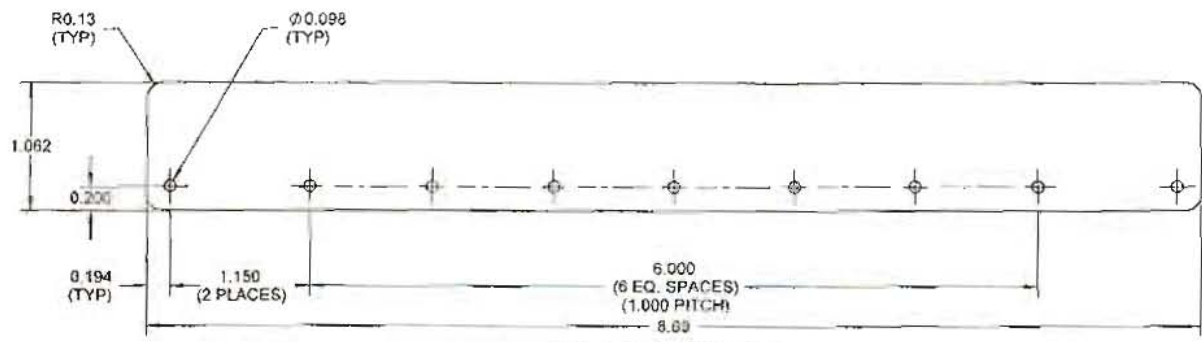
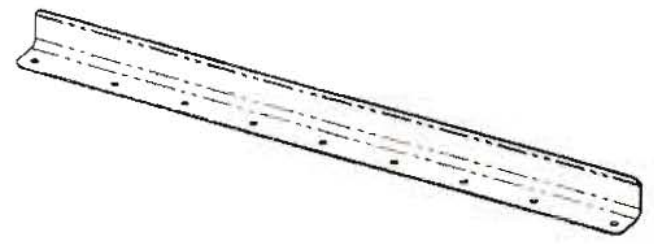
NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF: DART SPEC. M304523-1)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs



DESIGN	REV	DART AEROSPACE LTD	
DRAWN	REV	HAWKESBURY, ONTARIO, CANADA	
CHECKED	REV	DRAWING NO.	REV. B
MFG. APPR.	REV	D3245	SHEET 5 OF 7
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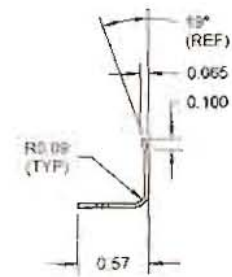
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D3245-5F FLAT PATTERN



D3245-5 BEND DETAIL
(MAKE FROM D3245-5F)

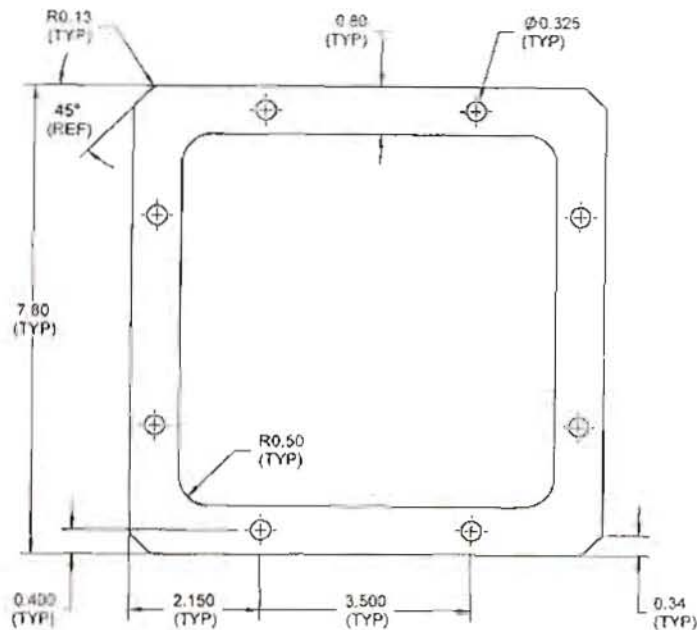


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07.10.02

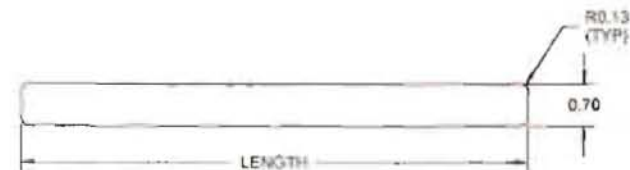
u/b 69322

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. N/A S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 010 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

DESIGN	1	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3245	SHEET 6 OF 7
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DE APPR.	PH	ACCESS PANEL ASSEMBLY	1:1
DATE	07.10.02	COPYRIGHT © 1994 BY DART AEROSPACE LTD	



D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

RELEASED
(W 07/02)

NOTES

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK (PER MIL-A-1021C OR MIL-A-17472B OR MIL-G-12503A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER ASMT QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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DRAWN			SHEET 7 OF 7
CHECKED			
MFG. APPROV.			
APPROVED			
DATE	07.10.02		

w/o 69322